



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D3197-041
Job Sheet 191866

Part No: D3197-041

Job Qty: 8 pcs

Part Name: Bar



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 4/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev: A New Issue 05-11-08 JLM IPP Rev: B As per Rev B 06-03-10 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	8 pcs	4/10/19	4/10/19	0.00	0.70	Bandsaw - 1		DAS 52 9-89	19/05/25
110	HAAS 4 Axis - B4B	8 pcs	4/10/19	4/10/19	0.51	5.93	HAAS - 1 - B4B		DAS 52 9-89	19/05/25
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
120	QC 2	8 pcs	4/10/19	4/10/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52		DAS 52 9-89	19/05/25
							QC 2 - 54			
							QC 2 - 56			



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CANADA
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Container No: S184045



Part: D3197-041

Job No: 191866

Serial No/Batch: S184045

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/28/19

						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
130	Conventional Lathe - 1 - B4B	8 pcs	4/10/19	0.00	1.41	Conventional Lathe - 1 - B4B	DAS 52 19/05/25 9-89
						Conventional Lathe - 2 - B4B	
140	QC 8	8 pcs	4/10/19	0.00	0.00	QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
150	Handfinish - 1-1 Chemical-B4B	8 pcs	4/10/19	0.00	0.69	Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
160	Powdercoat - 3 Grey Sand-B4B	8 pcs	4/10/19	0.00	0.35	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
START: 8:55 A.T.: 3:00 Finish: 19:25							BL 14.05.21
Plex 3/11/19 10:55 AM Dart.lajeunesse.marie							

170 QC 3	8 pcs	4/10/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	DAS 58 MAY 28 2019 9-89
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
180 Small Fab - 2 - B4B	8 pcs	4/10/19	0.00 2.05	Small Fab - 1 - B4B	DAS 58 MAY 28 2019 9-89
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
190 QC 5	8 pcs	4/10/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS JUN 11 2019 40 9-89
200 Packaging 3-1 - Stock - B4B	8 pcs	4/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	

					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC ST 256.
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	DAG
					QC 21 - SA - 70	21 JUN 11 2019
					QC 21 - SA - 53	9-55
210 QC 21 - SA	8 pcs	4/10/19	0.00 0.00			

Part Op 100 - (Bandsaw) Cut blanks: 29.125" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Face ends to length per dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (Manufacture as per dwg) Chamfer as per Dwg D3197
 140 - (QC8- Inspect parts - second check)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Small Fab) Assemble D3197-041 as per Dwg D3197
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73R1.000	7075-T73 Round Bar 1.00	19.3600 ft (2.42 ea)	100-Bandsaw - 1	516 8065
D2690-5	Lanyard Assembly	16 pcs (2 ea)	180-Small Fab - 2 - B4B	5184776
D3242-1	Tag	5019183 v6 16 pcs (2 ea)	180-Small Fab - 2 - B4B	5167911 x10
D3489-3-200	Pip Pin 1X	16 pcs (2 ea)	180-Small Fab - 2 - B4B	5151275 v3 5181852 x12
MS21042L3	Nut	16 Ea (2 ea)	180-Small Fab - 2 - B4B	5166712
MS27039-1-24	Screw	5134537-10 x10 16 Ea (2 ea)	180-Small Fab - 2 - B4B	5043817 x6
NAS1149D0363J	Washer	48 Ea (6 ea)	180-Small Fab - 2 - B4B	5162884

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73R1.000	19	4	0
180-Small Fab - 2 - B4B	D2690-5	16	4	0
	D3242-1	16	8	0
	D3489-3-200	16	5	0
	MS21042L3	16	3,908	0
	MS27039-1-24	16	110	0
	NAS1149D0363J	48	963	0

Part Specifications

Specifications could not be found.

Plex 3/11/19 10:55 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	191866
Description: Bar		Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	✓		TAPE	
25.06	+/-0.030	25.06	✓		TAPE	
11.44	+/-0.030	11.44	✓		TAPE	
0.500	+/-0.010	0.501	✓		Ver	
0.250	+/-0.030	0.250	✓		Ver	
Ø0.219	+0.005/-0.000	0.219	✓		G.P.	
Ø0.191	+0.005/-0.000	0.191	✓		G.P.	
1.000	+/-0.005	0.999	✓		Ver	
2.69	+/-0.030	2.685	✓		Ver	
1.000	+/-0.010	0.999	✓		Ver	
0.300	+/-0.010	0.300	✓		Ver	
0.063 x 45°	+/-0.010	0.063 x 45°	✓		Ver	
Ø1.000	+/-0.010	0.999	✓		Ver	

Measured by: ^{DAS} 52	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 19/03/25	Date: 19/05/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition			Completed By		
					Lead hand / Supervisor		
					QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							